

Work Order ID 57952

April 21, 2010 8:42:49 AM



Page 1

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Item Name: Support Assembly

Stop



Start Date: 21/04/2010 Start Qty: ³⁷~~40.00~~



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *10-4-21*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble support as per Dwg D3278. ☐ ***DO NOT TIGHTEN BOLTS*** ☐ Identify as D3278-041

EP 10/04/20 (57)

center
(37)

EP 10/05/04 (37X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

8/10/05/04

(37)

Counted

140



Packaging

Packaging

Identify as per dwg & Stock Location: 51

0.00

0.00

Memo

8/10/05/05 (37)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/05/06

CL 10/5/14

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Picklist Print

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Work Order ID: 57952

Parent Item: D3278-041

Parent Item Name: Support Assembly

Comments: IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐



IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3278-1		Manufactured	No			100	Each	44.0000	40.0000			
												
Support												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST048

44

51353

7

55448

37

D3278-2

Manufactured No



Support

100

Each

62.0000

40.0000



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST048

62

53802

2

55449

60

D3278-3

Manufactured No



Spacer

100

Each

107.0000

40.0000



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST049

107

53803

107

EP 10/04/20

EP 10/04/20

EP 10/04/20

39

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			100	Each	1,473.000	80.0000			



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST139

2

111827

2

Main Warehouse

ST300

971

113422

112

114108

851

9063

8

Main Warehouse

ST463

500

114416

500

120

Each

99.0000

80.0000

AN4-13A



Bolt

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST357

99

114181

6

114330

3619

114416

50

4828

7

114495 (11x)

19x
3619
44x

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Shop Packet Print

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Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416	057017	Purchased	No			120	Each	0.0000	100.0000			
Washer	NAS1149D04631				M113706							
D2230-1		Manufactured	No			120	Each	31.0000	80.0000			
Lug												

Warehouse

Location

Main Warehouse

ST476

54755

Loc Qty

31

31

Loc Code

3 57828

MS20426AD3-6

Purchased

No

120

Each

2,214.000

100.0000

Rivet

Warehouse

Location

Main Warehouse

ST316

105055

Loc Qty

2214

2214

Loc Code

160

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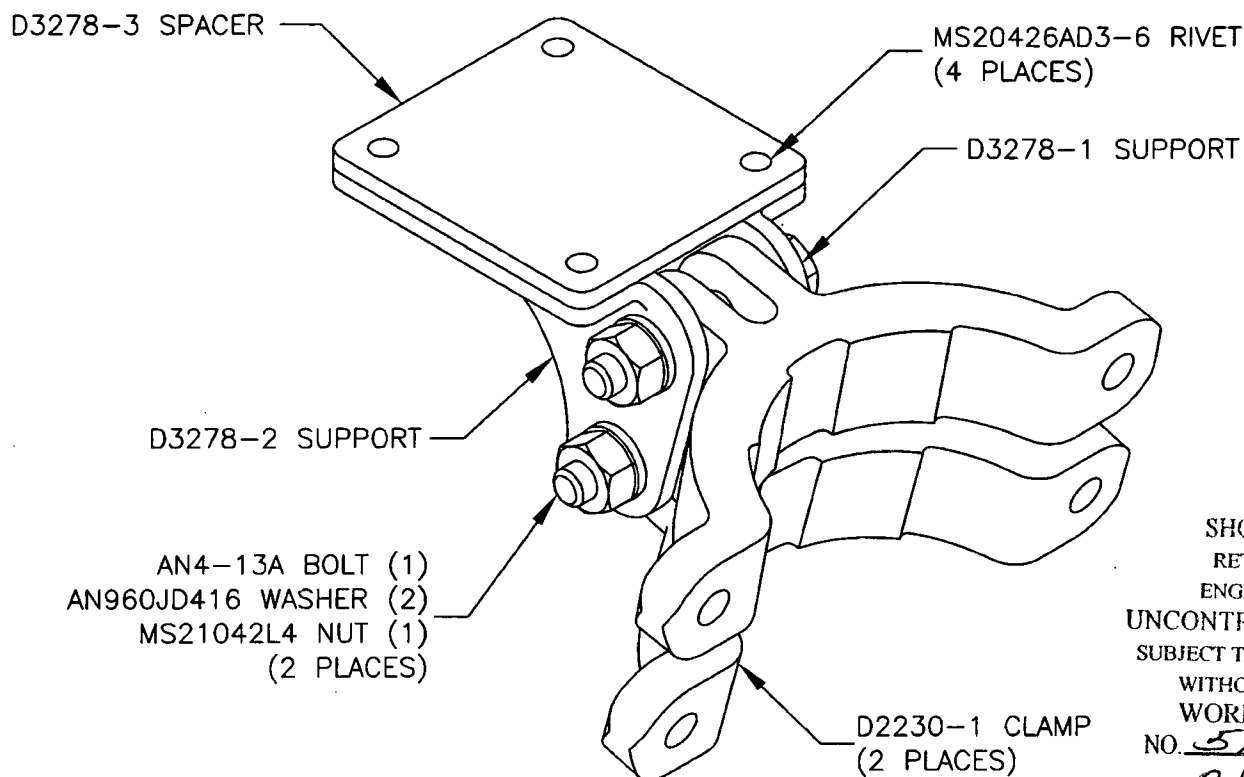
NOTE: Date & initial all entries

DART

DESIGN <i>97</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *57952*
BS10-4-24

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

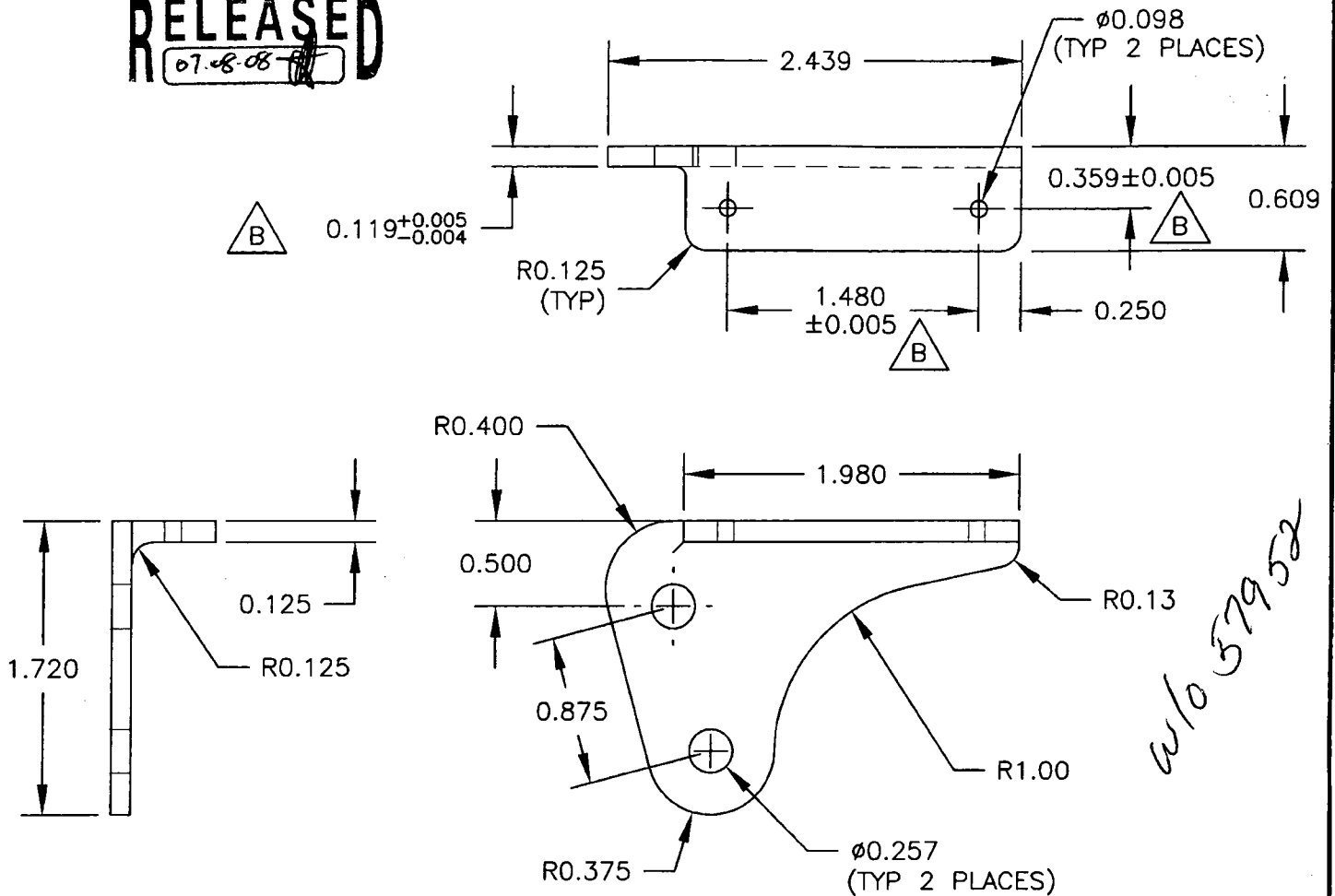
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>dc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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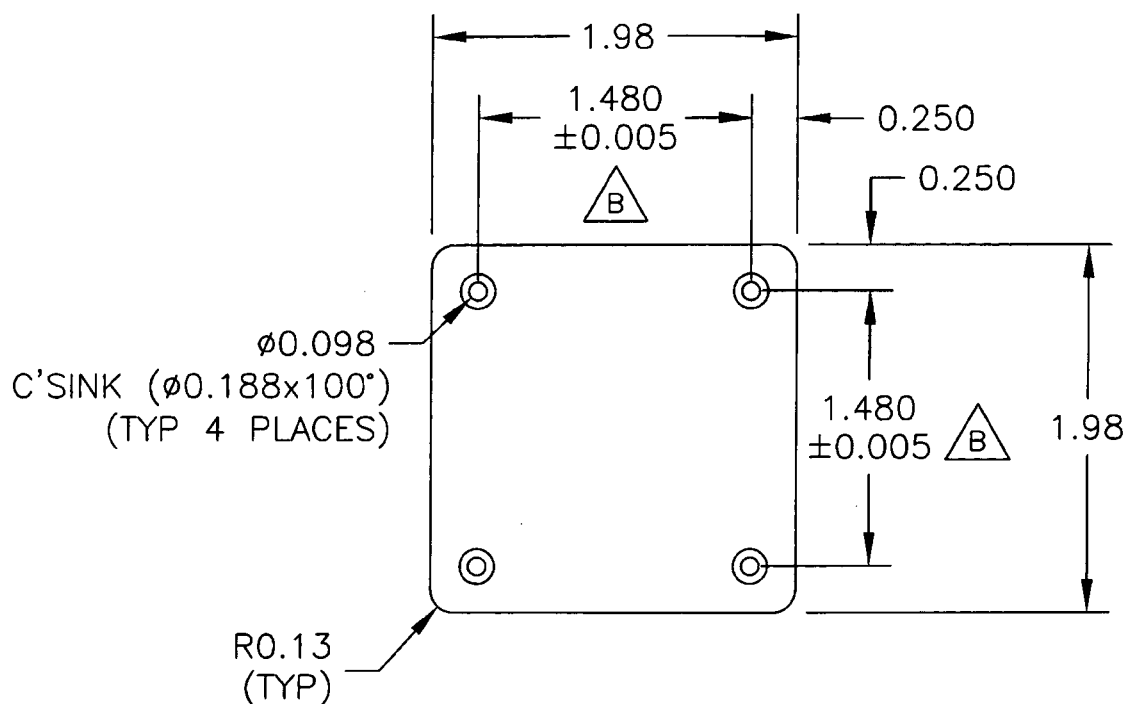
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08

w/o 57952



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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